

WHAT IS CLAIMED IS:

1. Bottoming device for cross bottom paper bags (1)
 - that forms the cross bottoms (1) of paper bags
 - in that it implements folds at the extremities of tubular segments from which the bags (1) are produced
 - that in this manner applies glue layers to the folded bottoms (1) on the extremities of the tubular segments and/or the sheets (2) intended to be glued with the bottoms (1) with the help of gluers (10, 20, 30, 40)
 - connects and glues the folded bottoms (1) and the sheets (2).

characterized by the fact that

- at least one gluer (10, 20, 30, 40)
- that is equipped with at least one glue reservoir (21) or at least one glue duct (33, 52, 53) in which glue is exposed to a pressure that is higher than the ambient pressure
- and whereby the at least one glue reservoir (21) or the at least one glue duct (33, 52, 53, 55, 72, 73) is provided with at least one glue output orifice (71) through which glue is directly applied on the sheets (2) and/or folded bottoms (1).

2. Bottoming device in accordance with claim 1

characterized by the fact that

the glue transfer can be carried out between the at least one glue output orifice (71) or other glue carrying components of the bottoming device and the sheets (2) and/or folded bottoms (1) in a contact-free manner.

3. Bottoming device in accordance with one of the aforesaid claims

characterized by the fact that

the glue ducts (33, 52, 53, 55, 72, 73) that supply glue to the glue output orifices (71) have at least one valve (32).

4. Bottoming device in accordance with one of the aforesaid claims

characterized by the fact that

- in the gluing station (10, 20, 30, 40, 50, 60, 70) an application head (31, 41, 50, 60, 80) is provided

- that contains at least one component of at least one glue reservoir (21) or of at least one glue supply line (33, 52, 53, 55, 72, 73) and
- to which at least one glue output orifice (71) is assigned.

**5. Bottoming device in accordance with claim 4
characterized by the fact that**

the application head (31, 41, 50, 60, 80) has several glue output orifices (71).

6. Bottoming device in accordance with claim 5

characterized by the fact that

the application head (31, 41, 50, 60, 80) has a plate-like form (61)

whereby the glue output orifices (71) are provided on the side (76) facing the bag component to be glued.

7. Bottoming device in accordance with one of the claims 4 to 6

characterized by the fact that

valves (32) are attached to the application head (31, 41, 50, 60, 80).

8. Bottoming device in accordance with claim 7

characterized by the fact that

the valves (32) are attached on the side (66) of the application head (31, 41, 50, 60, 80) facing away from the bag components to be glued.

9. Bottoming device in accordance with claim 7 or 8

characterized by the fact that

at least one component of the glue output orifices (71) in the direction in space (y) running transverse to the transfer direction have a distance (A) between one another that is smaller than the breadth (B) of the valves (32).

10. Bottoming device in accordance with one of the claims 7 to 9

characterized by the fact that

more glue output orifices (71) than valves (32) are provided on the application head (31, 41, 50, 60, 80).

11. Bottoming device in accordance with one of the claims 5 to 10
characterized by the fact that

the glue output orifices (71) that are provided in the application head (31, 41, 50, 60, 80) are located in one line running essentially transverse to the transfer direction (y) of the bag components (1,2) to be glued.

12. Bottoming device in accordance with one of the claims 5 to 11
characterized by the fact that

the valves (32) are provided with glue by at least one borehole or chamber (52, 53) in the application head (31, 41, 50, 60, 80).

13. Bottoming device in accordance with claim 12
characterized by the fact that

at least one borehole or chamber (52, 53) runs essentially transverse to the transfer direction (x) of the bag components (1,2).

14. Bottoming device in accordance with one of the claims 7 to 13
characterized by the fact that

at least one part of the valves (32) on the application head (31) is arranged in the direction running offset to the transfer direction (x) of the bag components (1, 2).

15. Bottoming device in accordance with claim 14
characterized by the fact that

the valves (32) are arranged in different rows (VR1, VRn) that run transverse (y) to the transfer direction (x) of the bag components (1, 2).

16. Bottoming device in accordance with one of the claims 4 to 15
characterized by the fact that

the application head (31, 41, 50, 60, 80) is mobile transverse to the transfer direction (y) of the bag components (1, 2) to be glued.

17. Bottoming device in accordance with one of the claims 4 to 16
characterized by the fact that

the application head (31, 41, 50, 60, 80) can swivel from the glue application position.

18. Bottoming device in accordance with claim 17

characterized by the fact that

the rotatable application head (31, 41, 50, 60, 80) can take up standstill positions dedicated to various definite functions.

19. Bottoming device in accordance with claim 18

characterized by the fact that

at least two standstill positions of the application head (31, 41, 50, 60, 80) are intended that are dedicated to at least two of the following functions:

- application of glue on the bag components (1, 2) to be glued
- sealing the glue output orifices (71)
- wipe off the glue contaminating the application head (31)
- rinse the application head (31)

20. Bottoming device in accordance with one of the claims 4 to 19

characterized by the fact that

the distance between the output orifices (71) can be freely selected during the application of glue on the bag components (1, 2) to be glued.

21. Bottoming device in accordance with one of the aforesaid claims

characterized by the fact that

the at least one glue duct (33, 52, 53, 55, 72, 73) or the at least one glue reservoir (21) has a water connection.

22. Bottoming device in accordance with claim 21

characterized by the fact that

the water connection has a check valve.

23. Bottoming device in accordance with one of the aforesaid claims

characterized by the fact that

the at least one glue duct (33, 52, 53, 55, 72, 73) or the at least one glue reservoir (21) has at least one of the following characteristics:

- a pressure relief valve
- a pressure sensor
- a pressure controller

24. Bottoming device in accordance with one of the aforesaid claims
characterized by the fact that

- the application head (31) has a projection on the side (76) facing the bag components (1, 2) to be glued
- this projection is closer than the output orifices (71) during the glue application of the bag components to be glued (1, 2).

25. Bottoming device in accordance with one of the claims 4 to 24
characterized by the fact that
the application head (31) is provided with glue and/or water by flexible lines.

26. Bottoming device in accordance with one of the claims 3 to 24
characterized by the fact that

- at least one valve (32) that provides at least one glue output orifice (71) with glue can be controlled independent of the other valves (32),
- so that the application of the glue line (3) produced from the at least one glue output orifice (71) can be started and stopped selectively.

27. Bottoming device in accordance with claim 26
characterized by the fact that

the opening and closing of the at least one valve (32) can be carried out also during the glue application of a bag component (1, 2) to be glued.

28. Bottoming device in accordance with one of the claims 3 to 27
characterized by the fact that

at least 5 valves (32) are provided.

29. Bottoming device in accordance with claims 9 and 10

characterized by the fact that

the sum (D) of the distances (A) between the glue output orifices that are fed with glue from a valve in the direction in space running transverse (y) to the transfer direction (x) of the bag components (1, 2) to be glued is smaller than the breadth (B) of the valves (32).

30. Bottoming device in accordance with one of the aforesaid claims

characterized by the fact that

the glue channels (52, 53) that transport the glue to a majority of valves (32) have a common cross-sectional area that is at least half as large as the sum of the cross-sectional areas of the glue output orifices (71) that extrude this glue.

31. Bottoming device in accordance with one of the aforesaid claims

characterized by the fact that

a hard counter bearing—preferentially a metallic cylinder—is provided on which the bag components (1, 2) to be glued are located during the glue application.

32. Bottoming device in accordance with one of the claims 3 to 31

characterized by the fact that

in the transfer direction of the glue to the valves more stoppers are provided with which the glue channels (72, 73, 77, 115) and/or glue output orifices (71, 113) can be sealed.

33. Bottoming device in accordance with the aforesaid claim

characterized by the fact that

the sealability of the glue channels (72, 73, 77, 115) and/or glue output orifices (71, 113) is ensured by pins (120) and/or screws.

34. Bottoming device in accordance with the aforesaid claim

characterized by the fact that

the sealing of the channels (115) and/or glue outlet openings takes place with pins (120) that are held rotatably in a format plate system (119),
that (120) have a glue outlet that seals the channels (115) and/or output orifices (113) when the pins (120) are rotated.

35. Bottoming device in accordance with claim 33

characterized by the fact that

pins (120) or screws are inserted in at least a part of the output orifices (113)
whereby the main axes of inertia of the pins (120) or screws coincide with the
axis of the output orifice (113).

36. Process for the operation of a bottoming device in accordance with one of the
claims 3 to 35

characterized by the fact that

- at least one valve (32)
- that is active during the formation of a definite glue format (4)
- is opened or closed at other points of time than the other valves (32) during the
gluing of a bag component (1, 2).

37. Process in accordance with the aforesaid claim

characterized by the fact that

the period between the opening and the closing of the valve (32) amounts to less
than 5 milliseconds.